

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 51990

September 11, 2009 9:03:21 AM



Page 2

| | | | | | |
|--------------------------------|-----------------|--|-------|-------|--|
| Item ID: D3883-2 | Accept | | Setup | Start | |
| Revision ID: B | | | | Stop | |
| Item Name: Saddle, Outboard RH | | | | | |
| Start Date: 09/14/2009 | Start Qty: 4.00 | | | | |
| Required Date: 09/23/2009 | Req'd Qty: 4.00 | | | | |
| Reference: | | | | | |
| | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | <u>2</u> | | | |
| 130 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | <u>4</u> | | | |
| 140 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: OVEN TEMPERATURE: FINISH TIME: | 0.00 0.00 | | | | <u>4</u> | | | |

09/11/01

09-11-2

09-11-2

11/2/48

11:40
3200
12:40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 51990

September 11, 2009 9:03:21 AM



Page 3

Item ID: D3883-2

Revision ID: B

Item Name: Saddle, Outboard RH

Start Date: 09/14/2009 Start Qty: 4.00

Required Date: 09/23/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

LMO 09/11/02 xy

160



Packaging

Packaging

Identify as per dwg & Stock Location: 409

Memo

0.00

0.00

9/11/3 4x SP

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/11/03

MF
09-11-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

September 11, 2009 9:03:20 AM

Page 1

Work Order ID: 51990



Parent Item: D3883-2RevB



Parent Item Name: Saddle, Outboard RH



Start Date: 09/14/2009

Required Date: 09/23/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D6101-015RevB | | Manufactured | No | | | 100 | Each | 0.0000 | 4.0000 | | | |
|  | | | | | | | | |  | | | |
| Saddle Billet | | | | | | | | | | | | |

B 51834 XH

WL 09/10/31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|--|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 51990 |
| Description: Saddle, Outboard, RH | | Part Number: D3883-2 |
| Inspection Dwg: D3883 | Rev. B | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing and record below:

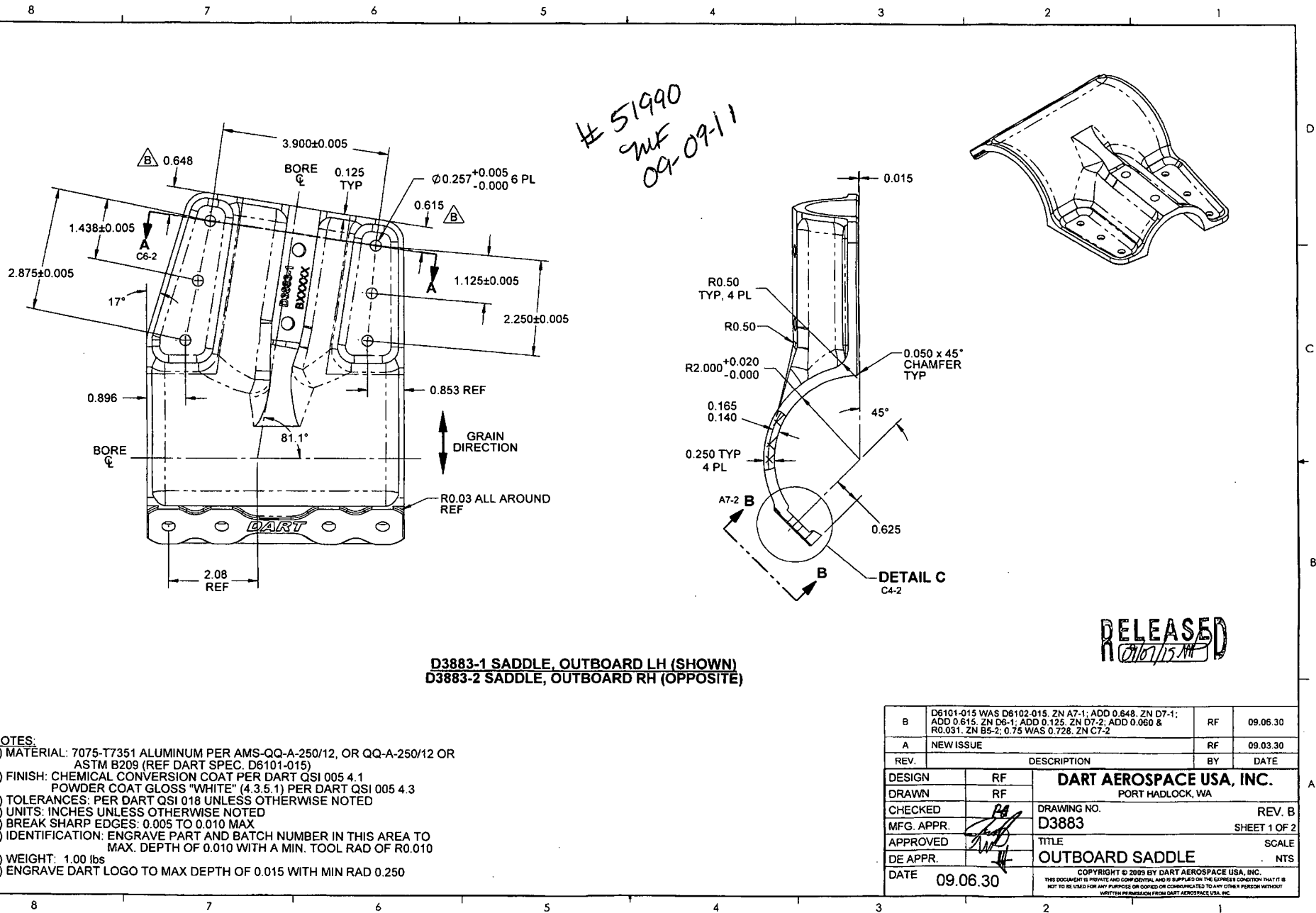
| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 2.870 | 2.880 | | 2.875 | 2.875 | 2.875 | 2.875 | | |
| B | 1.433 | 1.443 | | 1.438 | 1.438 | 1.438 | 1.438 | | |
| C | 0.638 | 0.658 | | .646 | .643 | .648 | .648 | | |
| D | 3.895 | 3.905 | | 3.900 | 3.900 | 3.900 | 3.900 | | |
| E | 0.257 | 0.262 | | .258 | .258 | .258 | .258 | | |
| F | 0.605 | 0.625 | | .613 | .614 | .616 | .616 | | |
| G | 1.120 | 1.130 | | 1.125 | 1.125 | 1.125 | 1.125 | | |
| H | 2.245 | 2.255 | | 2.250 | 2.250 | 2.250 | 2.250 | | |
| I | 2.000 | 2.020 | | 2.000 | 2.002 | 2.002 | 2.003 | | |
| J | 0.140 | 0.165 | | .152 | .152 | .151 | .151 | | |
| K | 0.240 | 0.260 | | .254 | .253 | .251 | .252 | | |
| L | 0.115 | 0.135 | | .122 | .125 | .125 | .125 | | |
| M | 0.140 | 0.165 | | .154 | .153 | .152 | .153 | | |
| N | 0.720 | 0.780 | | .740 | .740 | .740 | .740 | | |
| O | 0.240 | 0.260 | | .249 | .250 | .248 | .248 | | |
| P | 0.110 | 0.140 | | .130 | .130 | .130 | .130 | | |
| Q | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| R | 2.825 | 2.885 | | 2.868 | 2.868 | 2.868 | 2.868 | | |
| S | 0.316 | 0.321 | | .320 | .320 | .320 | .320 | | |
| T | 0.990 | 1.010 | | 1.002 | 1.002 | 1.007 | 1.004 | | |
| U | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| V | 5.990 | 6.010 | | 6.000 | 6.000 | 5.999 | 6.000 | | |
| W | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| X | 0.490 | 0.510 | | .500 | .498 | .500 | .499 | | |
| Y | 1.220 | 1.280 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| Z | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| AA | 0.313 | 0.318 | | .315 | .315 | .315 | .315 | | |
| AB | 0.020 | 0.040 | | .030 | .030 | .030 | .030 | | |
| AC | 0.760 | 0.765 | | .760 | .760 | .760 | .760 | | |
| AD | 0.215 | 0.220 | | .218 | .218 | .218 | .218 | | |
| AE | 1.265 | 1.285 | | 1.267 | 1.267 | 1.270 | 1.270 | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

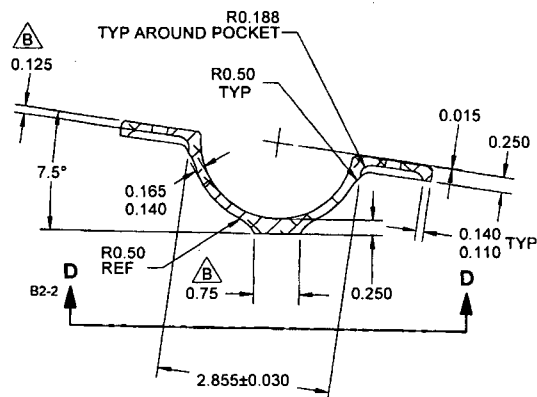
| | |
|--------------|----------|
| Measured by: | JL |
| Date: | 09/10/31 |

| | |
|-------------|----------|
| Audited by: | SP |
| Date: | 69/10/01 |

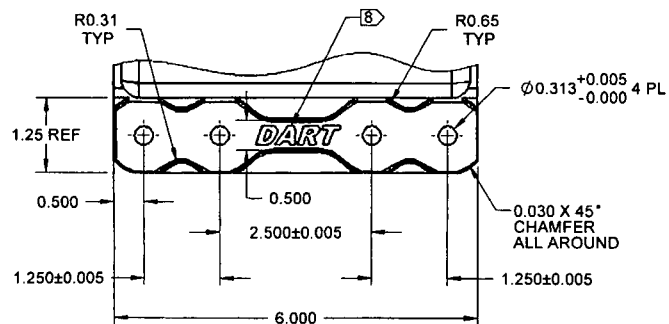
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 09.10.22 | New Issue | KJ | |

1.267

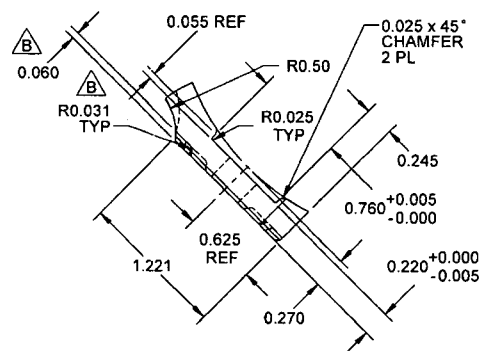




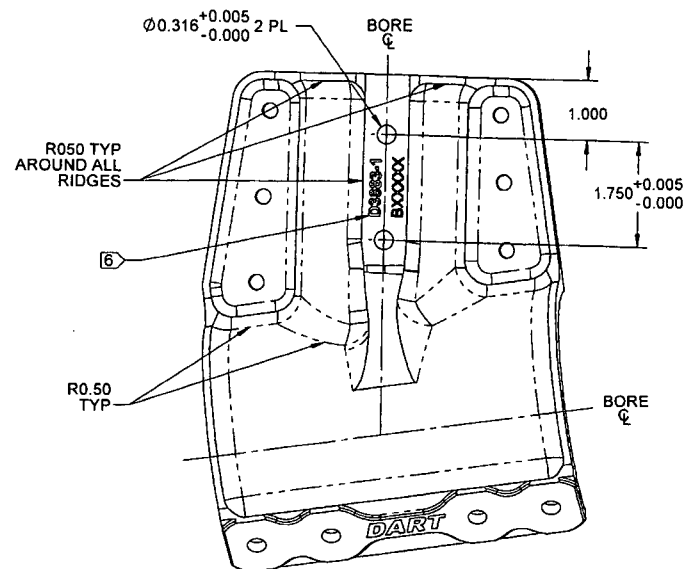
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

51990
RELEASED
09/07/15

| | | | |
|------------|----------|--|-----------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | RF | DRAWING NO. D3883 | REV. B |
| MFG. APPR. | | SHEET 2 OF 2 | |
| APPROVED | | TITLE OUTBOARD SADDLE | SCALE NTS |
| DE APPR. | | COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. | |
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